

Date: Wednesday, 1/10/2007 1:22:45 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER  
Job Number : 30227  
Estimate Number : 10685  
P.O. Number : *N/A* Part Number : D34553  
This Issue : 1/10/2007 S.O. No. : *N/A* Drawing Number : D3455 REV.A  
Prsht Rev. : NC Project Number : N/A  
First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : A  
Previous Run : 28172 Material : *N/A*  
Due Date : 1/17/2007 Qty: 40 Um: Each  
Written By : *[Signature]*  
Checked & Approved By : *[Signature]* 07.01.10  
Comment : EST REV. A 05.11.17 NEW ISSUE EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELRLNR1000 Delrin Round Bar 1"



Comment: Qty.: 0.0231 f(s)/Unit Total : 0.9240 f(s)  
Delrin round bar 1.00"  
(M-DELRIN-R1.000)  
Batch: *M103164*

*DP 07/01/11*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA584 & DWG D3455,  
FOLIO REV: *AA*  
DWG REV: *A*

2-DEBURR AS REQUIRED

*SB Jan 07/02/01 49 DP 07/01/12*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DP 07/01/12 49*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*ML 07/10/12 49*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




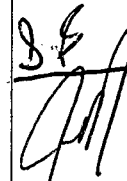

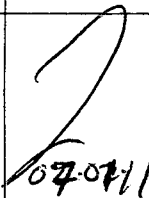
Comment: Deburr if necessary.

*SB 07/02/01 49*

# Dart Aerospace Ltd

W/O: 30227		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/01/11	2.0	Part off Rastine was off because the first part was .065" and the first was .035" and the folio was green.	S.F				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-11	2.0	1 Part scrap (1st one) ERROR in program when it part off it part off to thick for about .020"		Replace part. Adjust folio/Program.	 07-02-13			

NOTE: Date & initial all entries

Date: Wednesday, 1/10/2007 1:22:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 30227

Part Number: D34553

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/06 (49)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/02/06 (49)

07/02/06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(49)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/13

Job Completion



07-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3455</b>	REV. A SHEET 1 OF 1
DATE <b>05.09.02</b>		TITLE <b>SPACER</b>	SCALE 2:1
A	05.09.02	NEW ISSUE	

**RELEASED**05.12.09 *[Signature]* $\phi A^{+0.005}_{-0.000}$  $\phi B$ 

C

**D3455-X**1) SPECIFICATION: **D3455-X SPACER**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30227

**NOTES:**

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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